Quality Control

## **Picklist Print**

June-05-12 9:09:39 AM

Work Order ID: 85242

\*85242\*

Parent Item:

D412-742-013

\*D412-742-013\*

Parent Item Name: Float Skidtube Installation

**Start Date:** 05/06/2012

**Required Date:** 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev: A05.10.13New Issue KJ/JLM

IPP Rev:B 06-06-08 As per DSI9336 JLM

IPP RevC

07-12-03 ECN 1072

DD verified by:JLM

IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC

AN4C7A DD 10.01.13 verified by:EC

IPP RevF: add

DSI9517 REV.B DD verified by:EC IPP rev:H 12.01.12 PER IIN

IPP Rev:G 11.11.01 as per

REV.E DD VERF:

IPP Rev:I add AN4C47A DD 12.03.14

verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty p	er Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C47A		Purchased	No			110	Each	48.0000		4	4	/		
*AN4C47	7*								**			£ A	3	Ø

Location Loc Qty Loc Code ST361 118451 6 119798 2 121009 22 121585

D412-742-043

Manufactured

18 110 Each 0.0000

\*\*

Replacement Float Skidtube

									DQA:	Date:	•
NCR: Yes	/ No			W	ORK ORDER NON-	CONFOR	QA Closed: Date				
Work Order:	- 4			:	DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No.	:				Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	d. Eng. Coor. re/Packaging Supplier Other	Engineering Quality
Root				Description	of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or No	n-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling						¥					

#### Offset/Setup Other Process Supplier Training Unauthorized **FAULT CATEGORY Landing Gear** Hardware General Bending Passes Below Min Breaking Burrs Maintenance Set-up Mislabeled Centre Not Concentric to O/S Missing Contamination Supplier Temperature/Cure Cracks Size/Length Cut Too Short Off-Set Weld Crushed/Crimp at Bending Documentation/Data Spinning Orientation Misread Wrong Stock Pulled Inspection Strip in Tube Threading Out of Calibration Finish Wrong Inspection Incomplete Out of Sequence Other Inspection Unqualified Positioned Wrong **Drill Holes Outside Dimensions** Other Ripples on Inner Bend Misaligned Instructions Incomplete/Unclear Over/Under tolerance Torque Waves in Extrusion Ovalized Jigs/Fixtures/Tooling Part Lost Over/Undersized Kit Incorrect **Turning Sequence** Part Moved Wave/Twist in Tube Kit Missing Too Many Raw Material

Operator Material

## **Picklist Print**

June-05-12 9:09:39 AM

Work Order ID: 85242

Parent Item:

D2571

03242

D412-742-013 .

Manufactured

Manufactured

Manufactured

No

ST434

Parent Item Name: Float Skidtube Installation

\*85242\* \*D412-742-013\*

**Start Date:** 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

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18.0000

Required Qty: 1.00

i l

\*D2571\*
Saddle, Fwd Out 205

Saddle, Fwd In 205

Saddle, Aft Out 205

D2573

Locatio	<u>n</u>	Loc	Loc Qty					
ST			1					
	11644		1					
ST425			-13					
ST432			17					
	83451		5					
	83670		12					
ST433			13					
		110	Each	2.0000				

110

Each

2.0000 1 1 V \*\* 83452

Location	!	<u>Lo</u>	c Qty	Loc Code
ST432			2	
	71107		2	
		110	Each	22.0000

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<b>Location</b>	Loc Qty	Loc Code
ST423	-12	
79424	0	
ST433	22	2
83453	4	
83454	6	
83669	12	

12

JB 8 2/07/02

June-05-12 9:09:39 AM

NCR: Ye	es / No				<b>WORK ORDER NON-C</b>	CONF	FORM	MANCE / UPI	DATE			-		•
	j	1						(4)			QA Closed:	D	ate:	· •
Work Order	•				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part No.  NCR No.			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				Prod. Eng. Coor. Rec/Store/Packaging Supplier Other			Engineering Quality				
Root				Descri	ption of work order update	Ini	tial	Act	ion		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	ription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Offset/Setup Other Process Supplier Training Unauthorized								CONY				ē		
	- 6				Hardware	AULT	CATE	General	**	—				
Landin	Bending Centre I Cracks Crushed Inspecti Other Position Ripples	Passes Be Not Conce Crimp at on Strip ir ed Wrong on Inner E Waves in	entric to Bendin Tube Bend	o/s	Hardware  Breaking  Missing  Size/Length  Spinning  Threading  Wrong  Drill Holes  Misaligned  Ovalized	Co Co D Fi In	ut Too ocume inish nspecti nspecti	ination	Jnclear		Maintenan Mislabeled Off-Set Orientation Out of Calibe Out of Seque Outside Dim Over/Under Part Lost	Misread ration ence ensions		Set-up Supplier Temperature/Cure Weld Wrong Stock Pulled Other
	Horque	waves in	EXTRUSIO	n l	Ovalized	إالا	gs/riXt	.ures/ rooning			Irdii LOSI			

Kit Incorrect

Kit Missing

DQA:

Part Moved

Raw Material

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

Turning Sequence

Wave/Twist in Tube

Over/Undersized

Too Many

June-05-12 9:09:39 AM

\*85242\* Work Order ID: 85242 Parent Item: D412-742-013 \*D412-742-013\* Parent Item Name: Float Skidtube Installation **Required Date: 19/06/2012 Start Date:** 05/06/2012 Start Qty: 1.00 Required Qty: 1.00 D2574 Manufactured No 110 Each 22.0000 \*\* Saddle, Aft In 205 Location Loc Qty Loc Code ST433 22 83455 83456 6 83671 83671 12 D2876 Manufactured No 110 132.0000 Each \*\* Location Loc Qty Loc Code ST020 132 9 79693 83323 40 83890 83 D2877 Manufactured No 110 102.0000 Each \*\* Saddle Spacer Location Loc Oty Loc Code ST020 102

39

63

83324

83891

#### **Picklist Print** June-05-12 9:09:39 AM Work Order ID: 85242 \*85242\* Parent Item: D412-742-013 \*D412-742-013\* Parent Item Name: Float Skidtube Installation **Required Date:** 19/06/2012 Start Date: 05/06/2012 Required Qty: 1.00 Start Qty: 1.00 D3403-1 Manufactured No 110 55.0000 Each \*\* Bushing Location Loc Qty Loc Code ST041 15 70696 15 ST042 40 80208 80219 4 81529 29 D3403-5 Manufactured No 110 Each 38.0000 \*\* Location Loc Qty Loc Code ST042 38 38 81531 D2747 No 110 172.0000 Manufactured Each \*\* Location Loc Qty Loc Code ST017 172 5 79520 81877 167 D3533-1 110 Manufactured No Each 106.0000

Set Screw

Location Loc Qty Loc Code ST053 106 80326 6 83892 100

\*\*

83892

Page 4

# **Picklist Print** June-05-12 9:09:40 AM

Parent Item:

Page 5

Work Order ID: 85242

\*85242\*

D412-742-013

Parent Item Name: Float Skidtube Installation

**Start Date:** 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

16

Required Oty: 1.00

AN4C6A \*AN4C6A\* Purchased

No

110

Each

567.0000

\*\*

16

Purchased

No

21658

103344

116704 121656

Location

FG

ST356

Location

Location ST361

ST361

\*D412-742-013\*

2 61 500 110 Each

Loc Qty

4

563

22.0000

Loc Code

AN4C52A \*AN4C52A\*

Purchased

No

121183

22 Each

22

Loc Qty

56.0000

Loc Code

\*\*

\*\*

AN6C12A

Purchased No

117688 120364

56 6 50 110 Each

Loc Qty

38.0000

Loc Code

120364

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Loc Qty Loc Code Location ST341 38

110

121541

38

215411

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Picklist Print June-05-12 9:09:40 AM						*				Page 6
Work Order ID: 85242		*Q	5242*							
Parent Item: D412-742-013			112-742-0°	10*						
Parent Item Name: Float Skidtube Ins	tallation	1 /	1417-147-()	1.3		Si	art Date:	05/06/2012	Required De	te: 19/06/2012
-4-							start Qty:		Required Q	
D3672-3	Manufactured	No		110	Each	655.0000	_	32	quii cu V	.,
*D3672-3*	Manaracturea			•••	Cuvii	033.000	**	32 0-4	10	SZ3
Phenolic Washer			7 (					2443	± 93	_ <i>&amp;</i>
Thenone Washer			<b>Location</b>	Lo	c Oty	Loc Code			V	
			ST060		655	<u>Lot Cout</u>				
/			84361		655			84361		
AN960C416L NAS/149 CO 432 R	Purchased	No		110	Each	0.0000	32	32	/	_
*AN960C416I *							**	1212	58 J.B	SP SP
/ D3672-9	Manufactured	No		110	Each	348.0000	8	8 4		
*D3672-9* Phenolic Washer						. 0	**		J.B	R
			Location	Lo	c Qty	Loc Code				
			ST060		348			,		
,		•	81763		348			81763	<u> </u>	
MAS1149C0632R	Purchased	No	•	110	Each	231.0000		ے 8		- 0
*NAS1149C0632	R*						**		90	84
			Location	Lo	c Qty	Loc Code				
	+		ST297		231					
			119736		2			(4)	_	
			121060 121825		29 200			12142	ر	
/ D3672-11	Manufactured	No	121823	110	Each	243.0000	Q	1 2/ 02		Q
					Lacii	213.0000	**	0	1 2	<b>Y</b>
*D3672-11* Phenolic Washer							** **		JB.	12/07/0
			Location	Lo	c Qty	Loc Code				
			ST060		243			771102	-	
			77483		243			77483	-	
44										

Shop Packet Print

Page 6

June-05-12 9:09:40 AM

June-05-12 9:09:40 AM

Work Order ID: 85242

D412-742-013

Parent Item Name: Float Skidtube Installation

Parent Item:

MS21043-4

\*85242\*

\*D412-742-013\*

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Purchased No

Manufactured

Manufactured

No

No

110

Each

1,287.000

29

\*\*

<b>Location</b>	<u>Loc Q</u>	<u>)ty</u>	Loc Code			
FG		40				
104603		40				
ST301	1	247				
119546		131				
121162	1	616			121162	
121652	;	500		•		
	110	Each	29.0000	8	8 /	
				**	8566218	R
					<i>(</i>	

Each

Location Loc Qty Loc Code

110

ST042 29 81530 7 84503 22

16.0000

Loc Code

\*\*

83370 18 12/07/03

Lug Assembly

Location Loc Qty ST478 16 62227 2 77000 2 83896 12

Manufactured

No

D3417-3

Washer

Location Loc Qty ST463 25 82067 6 82068 19

31.0000 110 Each

\*\*

Loc Code Loc Qty Location FG 9 33519 22 ST042 80225 22

70225

June-05-12 9:09:41 AM

**Shop Packet Print** 

Page 8

### **Picklist Print** Page 9 June-05-12 9:09:41 AM \*85242\* Work Order ID: 85242 D412-742-013 \*D412-742-013\* Parent Item: Parent Item Name: Float Skidtube Installation **Required Date:** 19/06/2012 Start Date: 05/06/2012 Start Qty: 1.00 Required Qty: 1.00 D3456-1 Manufactured 110 Each 149.0000 \*\* Location Loc Qty Loc Code FG 7 25701 ST044 142 80252 81876 81876 41 83584 100 AN3C37A 141.0000 No 110 Each Purchased \*\* Location Loc Qty Loc Code ST354 141 116874 11 117010 120422 3 121068 121068 75

\*AN3C40A\*

 Location
 Loc Qty
 Loc Code

 ST354
 24

 114442
 24

110

50

Each

24.0000

\*\*

12/07/03

4442

121585

Purchased

No

Picklist Print June-05-12 9:09:41 AM				,						Page 10
Work Order ID: 85242		*85	242*					,		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
Parent Item: D412-742-013 Parent Item Name: Float Skidtub	e Installation		112-742-0	13*				05/06/2012	Required Date: 19/0	
						St	art Qty: 1	1.00	Required Qty: 1.00	)
, *AN3C41A* BOLT	Purchased	No		110	Each	138.0000	\ <b>★★</b>	1 2	JB	<b>- 201</b>
			<b>Location</b>	Loc	: Oty	Loc Code				01
			FG		4				- lo	
			103324		4			-	-	
			ST354		134				-	
4.			120753		24			12101	-	
			121013 121313		30 80			12/01		
AN3C42A	Purchased	No	121313	110	Each	32.0000	1	1 ,	-	
*AN3C42A*			(1)				**		JB 88	
			Location	Loc	: Oty	Loc Code				
			ST354		32			- C-		
		•	106176		1				-	
			120464		6			101/64	-	
1120424		3.1	121103	110	25	00 0000		12/109		
AN3C43A	Purchased	No		110	Each	92.0000	4	4		
z <b>*AN3C43A*</b>							**		18 SO12	108/0

 ST354
 92

 114455
 2

 119673
 1

 120465
 89

Loc Oty

Loc Code

**Location** 

June-05-12 9:09:41 AM

Work Order ID: 85242

D412-742-013

Parent Item Name: Float Skidtube Installation

\*85242\*

\*D412-742-013\*

Start Date: 05/06/2012

**Required Date:** 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Parent Item:

Purchased

No

110

Loc Qty

53

Each 53.0000

\*\*

\*AN3C46A\*

AN960C10L

NAS1149C0332

Purchased

Purchased

No

Location

ST355

120447 110

53 Each 0.0000

26

26

\*\*

\*\*

22063

MS21043-3

washer

No

110

Each

1,557.000

Loc Code

13

13

Location		<u>L</u>	oc Qty	Loc Code	
FG			72		
	103691		72		- A -
GA		4	14	4	
	120693		14		
ST301			1471		
	118077		2		36.
	118614		51		
	118686		30		
	119758		20		
	121255		368		121255
	121708		1000		